

Date: Wednesday, 22/04/2009 1:52:34 PM
 User: Melanie Fauteux

see p10
 p38a

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET
 Job Number : 47379-2
 Estimate Number : 13851
 P.O. Number :
 This Issue : 22/04/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL / MED FAB
 Previous Run : 47232
 Part Number : D35703 GY
 Drawing Number : D3570 REV D PRELIM
 Project Number : N/A
 Drawing Revision : D PRELIM
 Material :
 Due Date : 23/04/2009
 Qty: split Um: Each
 Written By :
 Checked & Approved By : Mf 09-04-22
 Comment : Est Rev:A New Issue 09.04.14 EC verified by:DD

Additional Product

Job Number:



PRELIMINARY ISSUE

Seq. #: Machine Or Operation: Description :

1.0 M6061T6S125 6061-T6 .125 Sheet



Comment: Qty.: 0.0746 sf(s)/Unit Total : 0.2982 sf(s)

6061-T6 .125 Sheet

Batch: 110067

IB 9-4-22
 IB 9-4-24

Grain must be Along 4.63**

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3570

Dwg Rev: PLE

Prog Rev: Lim

2-Deburr if necessary

IB 9-4-24
 IB 9-4-22
 IB 9-4-24
 IB 9-4-22

M- / 09/04/23

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



ENGINEER'S
 APPROVAL

Comment: SECOND CHECK

SMALL & MEDIUM FAB RESOURCE 1

5.0 SMALL FAB 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Form as per Dwg D3570 Using DT8945

FF 09-04-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 22/04/2009 1:52:34 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 47379

Part Number: D35703

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Cut excess material per Dwg D3570.

3-Drill as per Dwg D3570 Using Dt8946

FF 09-04-23

6.0

QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING
APPROVAL



Comment: INSPECT WORK TO CURRENT STEP

09-06-23 (3)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

09-06-24

(13)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M109091

START TIME: 11:30am

OVEN TEMPERATURE: 320°C

FINISH TIME: 12:00pm

09-06-24 (8)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-06-24

(8)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: 245A

9/6/24

31
JLHSA

SP

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/25

Job Completion



POSITIVE RECALL

EFFECTIVE

RELEASED

AUTH

DATE

09-06-24

09/06/24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
7/1/23	#5	Pound all 5 parts to be bent too long. Day Ask Per 3.96 measure dont 4.100 to 4.160"	09.04.23 Per QA	Scrap and Destroy 110062 Reprc B# 110062 and re form and drill As per DWG	FF 29-04-24 Bq401		09.04.23 Per 08/04/23	S 09/04/23
		RC						S 09/04/23

NOTE: Date & initial all entries

8

7

6

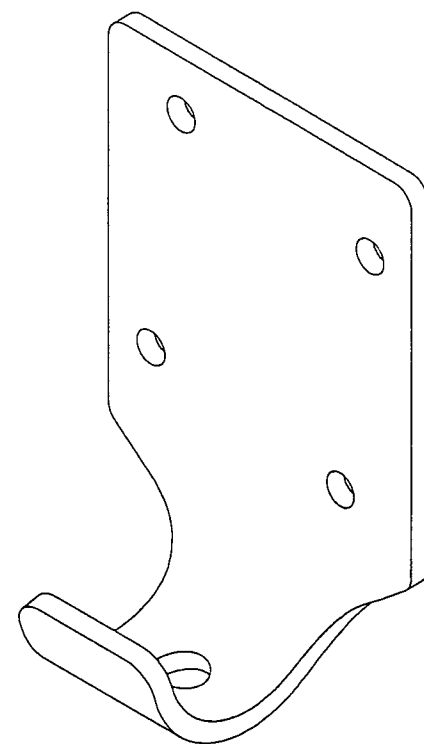
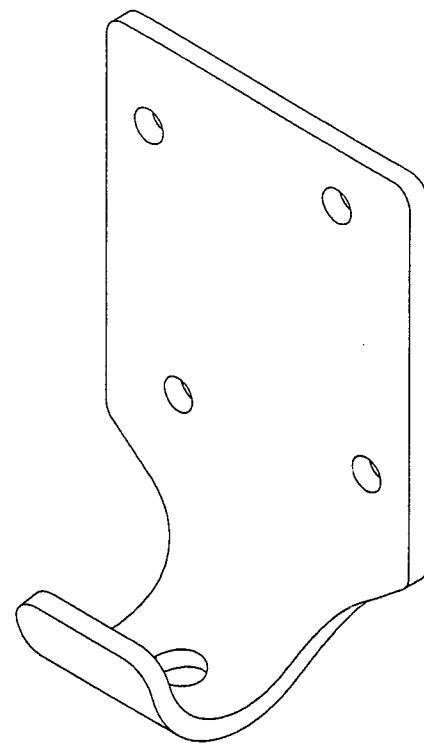
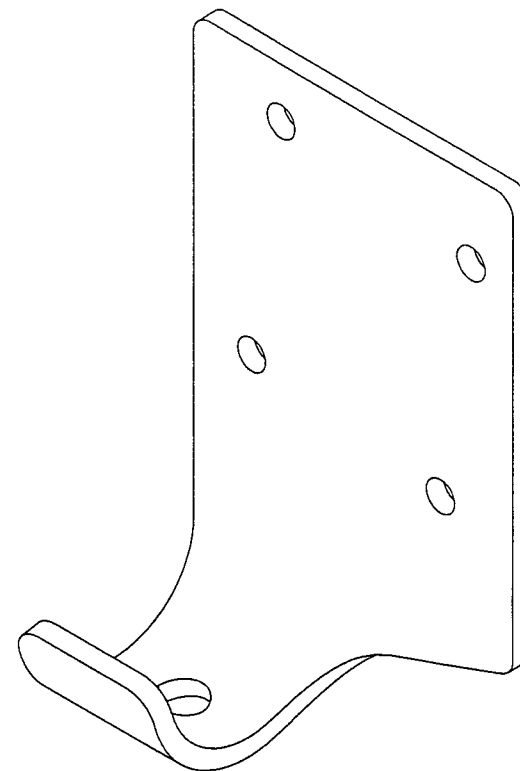
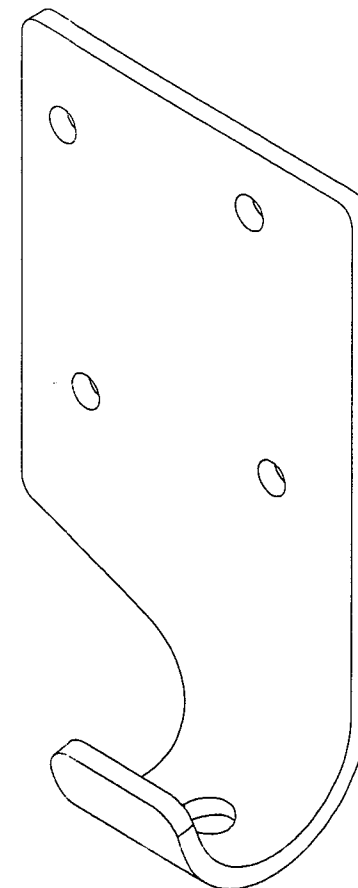
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4

3

2

1

**D3570-1 BRACKET****D3570-2 BRACKET****D3570-3 BRACKET****D3570-4 BRACKET**

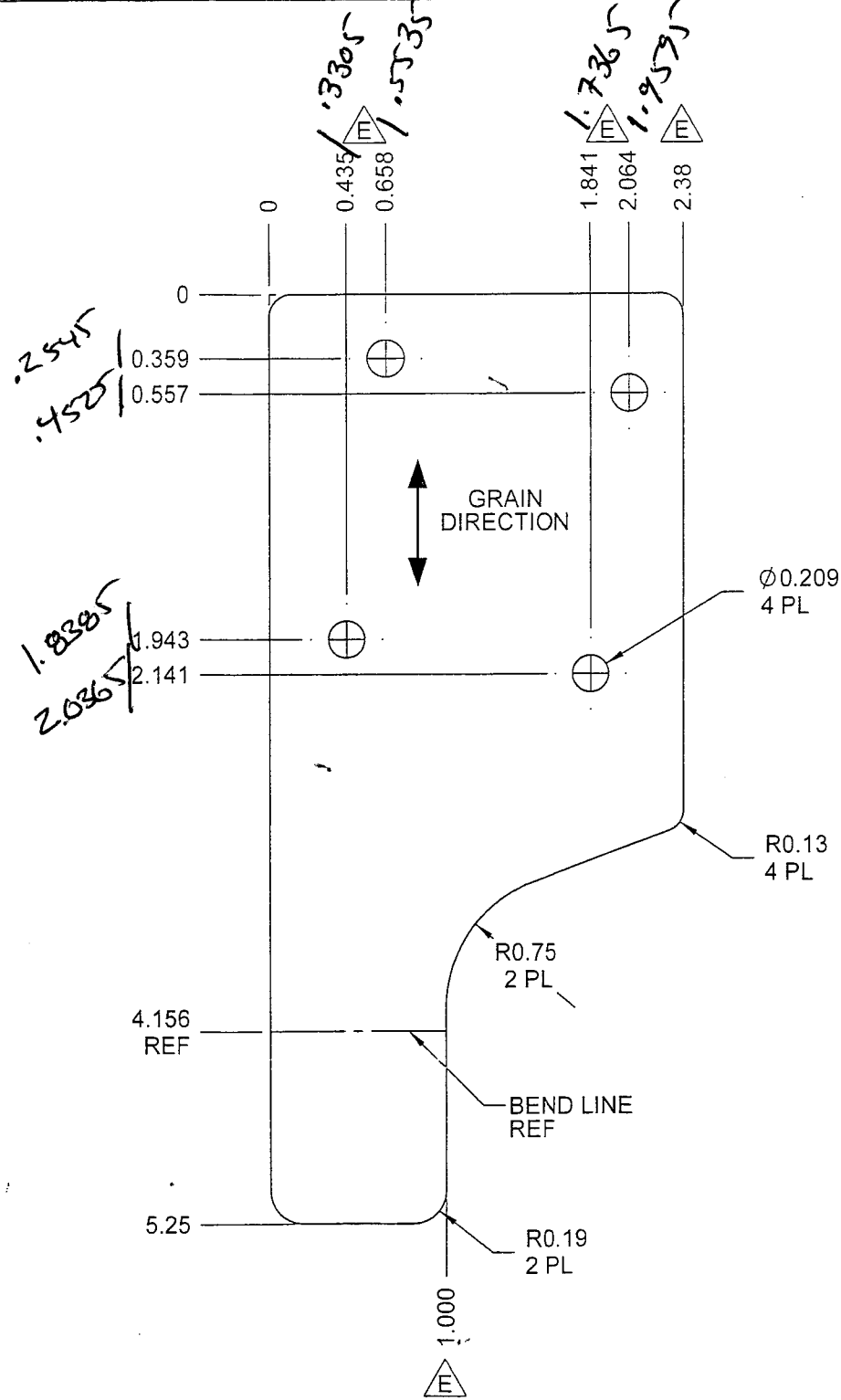
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NOTES:

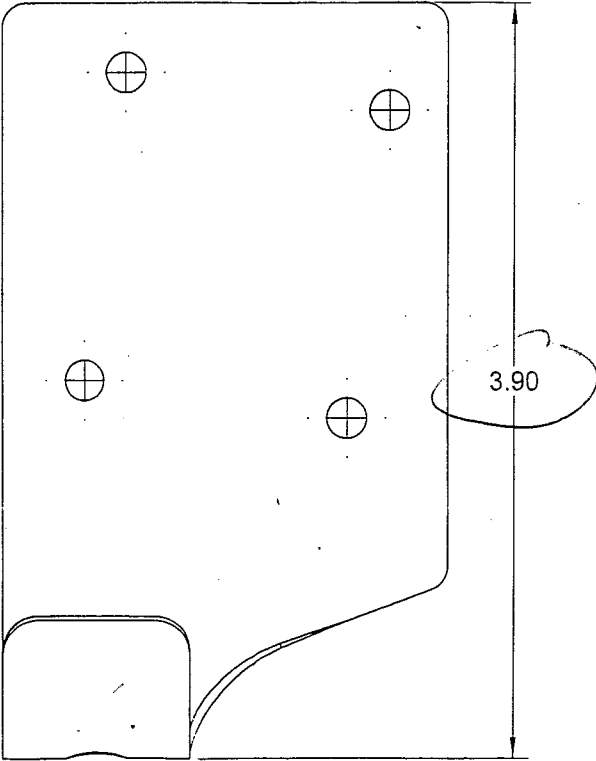
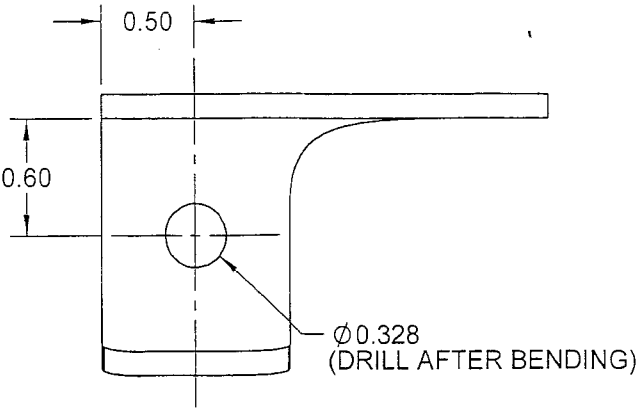
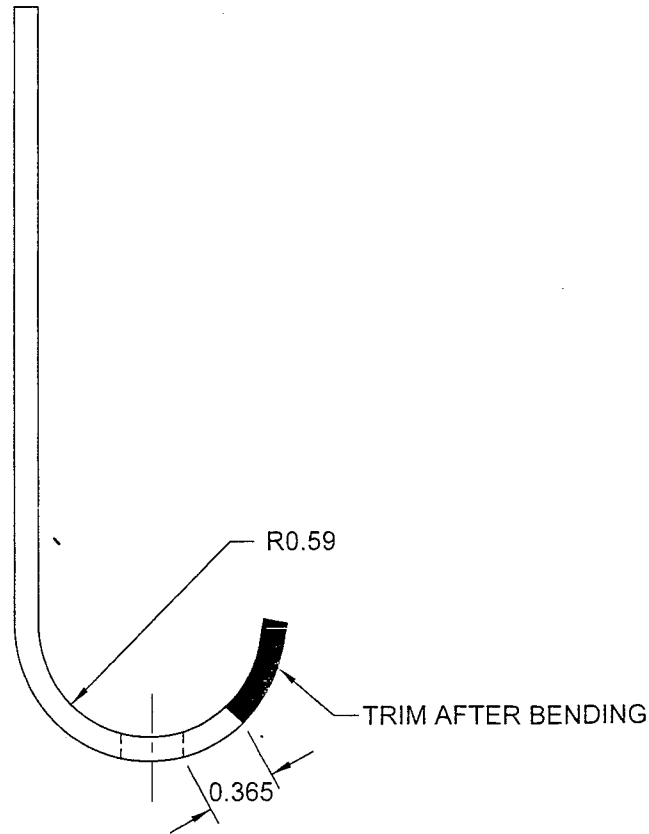
- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3570-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs EACH

PRELIMINARY
ISSUE
AJS 09.04.22

E	SHEET 3 UPDATED D3570-3F FLAT PATTERN, SEE REV D FOR DETAILS. SEE PAR 09-014.		AJS	09.04.22
D	ADDED -3 & -4 FOR USE ON 214B/B1. SEE PAR 09-014.		AJS	09.04.01
C	UPDATE DIMS FOR CLARITY		LE	07.06.01
B	CHANGE BEND RAD TO 0.60 FROM 0.50		LE	07.04.16
A	NEW ISSUE		LE	07.02.07
REV.	DESCRIPTION		BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED	LE	DRAWING NO.		REV. E
MFG. APPR.	LE	D3570		SHEET 1 OF 5
APPROVED	LE	TITLE		SCALE
DE APPR.	LE	BRACKET		NTS
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D3570-3F FLAT PATTERN

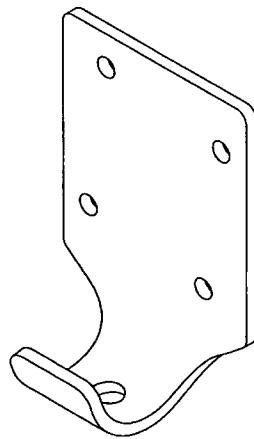


D3570-3 BRACKET
(MAKE FROM D3570-3F)

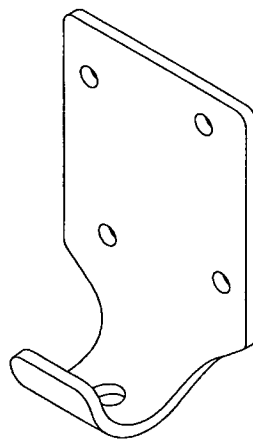
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PRELIMINARY
ISSUE
15504.04.22

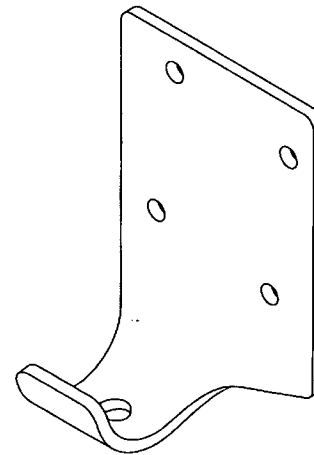
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DRAWN	AJS		
CHECKED	AS	DRAWING NO. D3570	REV. E
MFG. APPR.	ED	SHEET 4 OF 5	
APPROVED	WJD	TITLE BRACKET	SCALE NTS
DE APPR.		COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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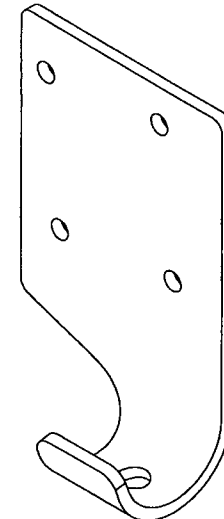
D3570-1 BRACKET



D3570-2 BRACKET



D3570-3 BRACKET



D3570-4 BRACKET

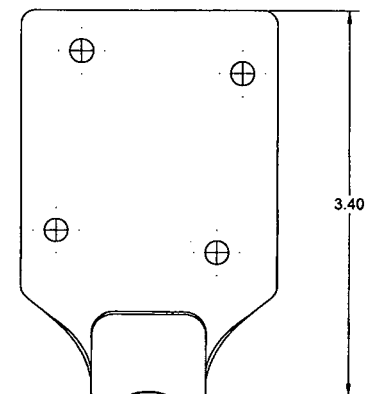
RELEASED
09/15/13

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3570-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs EACH

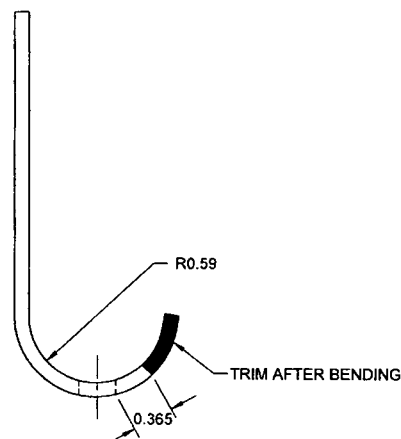
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E	SHEET 3 UPDATED D3570-3F FLAT PATTERN, SEE REV D FOR DETAILS. SEE PAR 09-014.	AJS	09.04.22
D	ADDED -3 & -4 FOR USE ON 214B/B1. SEE PAR 09-014.	AJS	09.04.01
C	UPDATE DIMS FOR CLARITY	LE	07.06.01
B	CHANGE BEND RAD TO 0.60 FROM 0.50	LE	07.04.16
A	NEW ISSUE	LE	07.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AJS	DRAWING NO.	REV. E
MFG. APPR.	AJS	D3570	SHEET 1 OF 5
APPROVED	AJS	TITLE	SCALE
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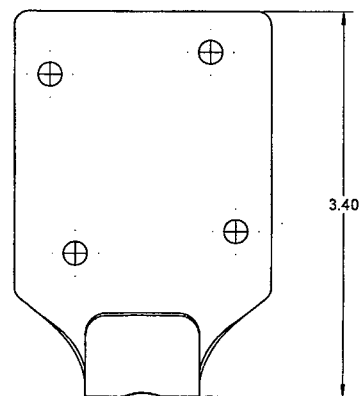
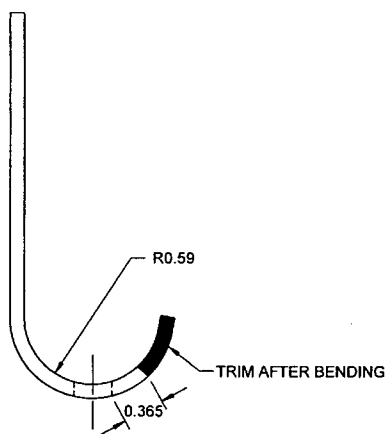
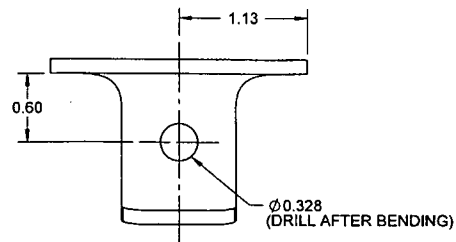


D3570-1 BRACKET
(MAKE FOM D3570-1F)

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29/04/23 NP



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DRAWN	AJS		SHEET 2 OF 5
CHECKED	<i>[Signature]</i>		SCALE
MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	09.04.22		

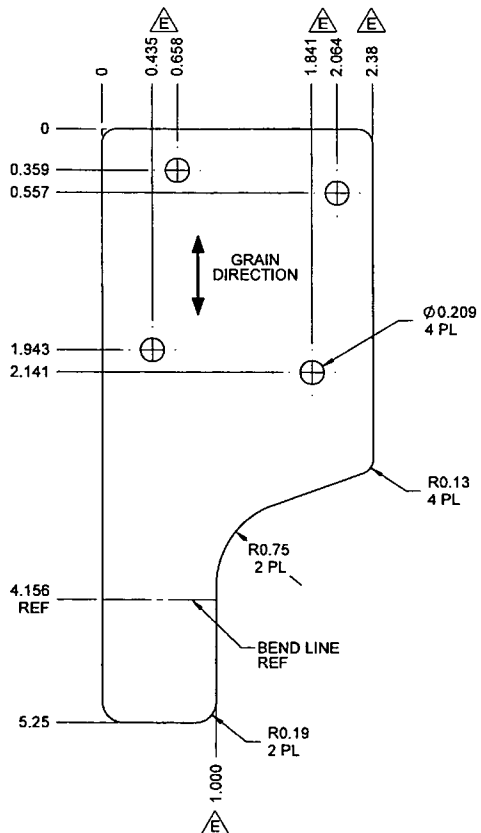


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(MAKE FROM D3570-1F)

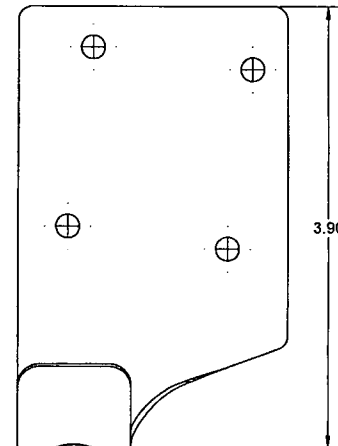
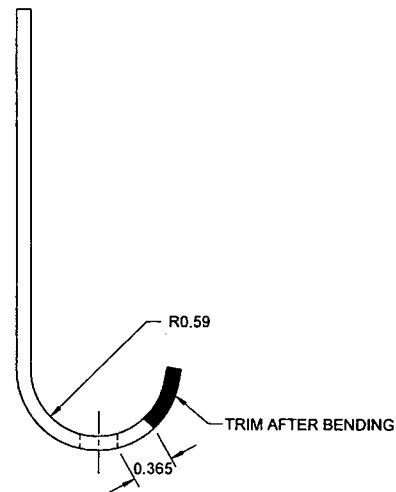
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09/04/22

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MFG. APPR.	E	D3570	SHEET 3 OF 5
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D3570-3F FLAT PATTERN

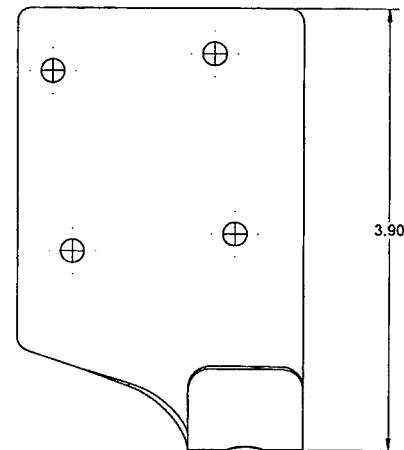
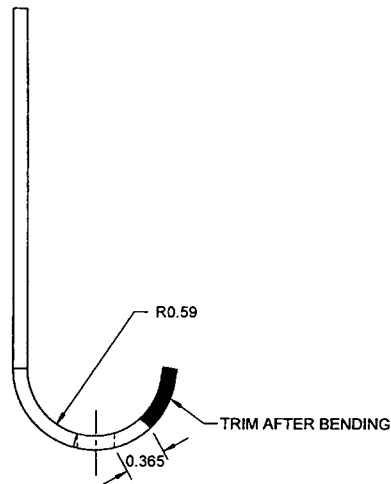
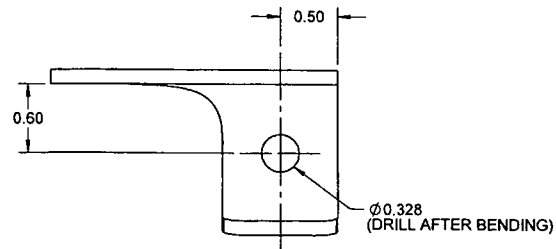


D3570-3 BRACKET
(MAKE FROM D3570-3F)

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07/24/23

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CHECKED	JE	DRAWING NO.	REV. E
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APPROVED	JE	TITLE	SCALE
DE APPR.	JE	BRACKET	NTS
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D3570-4 BRACKET
(MAKE FROM D3570-3F)

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MFG. APPR.	<i>[Signature]</i>	D3570	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
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